

Work Order ID 71116

Thursday, June 23, 2011 11:03:56 AM

SLP Aug 12



Page 1

Item ID: D2512

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid 205/350

Start Date: 6/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten signature

Date: 11/06/23

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2512	Rev E								
100	Weld per dwg A/R S.S. rod Batch: 117884	0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Cut 3/4" x 3/4" square tubing as per Dwg D2512								
	2-Cut (4) D2236 From D3166-3								
	3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305								
	4-Weld as per Dwg D2512 using Welding Jig DT 9436								
	Deburr as required								
	INSTALL D2012-117 CLEVIS ONLY ON D130-701-041								
110	QC9- Inspect visual per QS1004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

Handwritten: P 11.10.27 *(1x)* *Handwritten signature*

Handwritten: BE
Handwritten: P 11.10.27

Handwritten: 1 *Handwritten signature*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71116

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Page 2

Item ID: D2512

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Customer:

Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

S-110127

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

1XØ m-f 6/11/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

IXC M/L 6/14/03

M 118434

140

HandFinishing

0.00



HandFinish

Memo

0.00

Hand Finishing

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch: *M 118119*

M 118988

1 of 11/11/01

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

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Cust Item ID:

Required Date: 7/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 QC3- Inspect Part Finish

0.00



QC Memo

0.00

Quality Control

11 11 04 (1)

160 Identify as per dwg & Stock Location: w/o

0.00



Packaging Memo

0.00

Packaging

0136-701-043/371112

1 of 11/11/10

170 QC21- Final Inspection - Work Order Release

0.00



QC Memo

0.00

Quality Control

11/11/10

MF 11-11-07

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, June 23, 2011 11:03:51 AM

Page 1

Work Order ID: 71116

Parent Item: D2512

Parent Item Name: Basket Lid 205/350



Start Date: 6/23/2011

Required Date: 7/6/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: Rev IPP:M03.01.31 AddedD2012-117forD130-701-041KJ/RF
 IPP Rev:N06.04.05 Added level21 EC
 IPP REV:O ADDED D3490-1/-3 FOR D130-701-011/-043 10-04-20 JLM
 VERIFIED BY:DD
 IPP Rev:P 08-08-29 revE as per dwg DD verified by:EC
 IPP Rev:Q 08-09-24 plug holes prior to powder coating DD verified
 by:EC IPP Rev:R 10.06.29
 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D2012-117 		Manufactured	No			100	Each	43.0000	2	2		6/11-10-25	
Clevis													

Location	Loc Qty	Loc Code
WA	31	
69890	31	
WA005	12	
55729	12	

*** ONLY APPLICABLE ON D130-701-041 -IF
 NOT USED, PLEASE MARK N/A ***

✓ D2232-1 		Manufactured	No			100	Each	18.0000	2	2		6/11-10-25	
Basket Hinge													

Location	Loc Qty	Loc Code
WA	18	
70842	18	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Thursday, June 23, 2011 11:03:51 AM

Page 2

Work Order ID: 71116

Parent Item: D2512

Parent Item Name: Basket Lid 205/350

Start Date: 6/23/2011

Required Date: 7/6/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D2327-1
Spacer Bushing

Manufactured No

100 Each

31.0000

2 2



6/11/10/24

Location

Loc Qty

Loc Code

WA

20

69728

20

WA005

11

64899

11

100 Each

5.0000

1 1



6/11/10/25

✓ D2506
Label Plate

Manufactured No

Location

Loc Qty

Loc Code

WA

5

69262

5

100 Each

105.0000

2 2



6/11/10/25

✓ D2581
Mounting Bracket

Manufactured No

Location

Loc Qty

Loc Code

WA

105

68964

4

69258

28

69739

22

70766

51

100 Each

2.0201

1 1



6/11/10/24

* D3166-3
Basket Hoop

Manufactured No

Location

Loc Qty

Loc Code

WA007

2.02010527

64928

0.02010527

68442

2

370189 → ①

Thursday, June 23, 2011 11:03:52 AM

Shop Packet Print

Page 2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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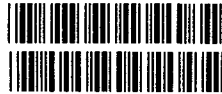
Picklist Print

Thursday, June 23, 2011 11:03:52 AM

Work Order ID: 71116

Parent Item: D2512

Parent Item Name: Basket Lid 205/350



Start Date: 6/23/2011

Required Date: 7/6/2011

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F Purchased No

100 sf

479.0034

18

18.94737



Expanded Metal Flat SS



Pl 11.10.25

Location

Loc Qty

Loc Code

MAT

38.2107

117708

38.2107

WA

440.7927

115012

95

117197

102.9036

117455

16.0341

117896

226.855

m119180 → 18.9473

M304TS0.750W.065 Purchased No

100 f

565.5786

43.5804

45.87411



304 SQ Tube .75x.75x.065W



Pl 11.10.24

Location

Loc Qty

Loc Code

MAT018

451.7236

117598

374.0249

117636

77.6987

WA007

113.8549906

116267

99.549272

116763

14.3057186

m118778 → 45.87411

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

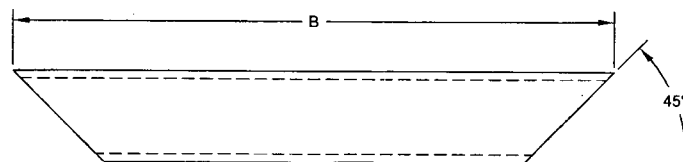
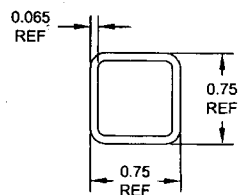
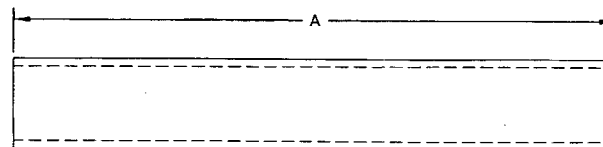
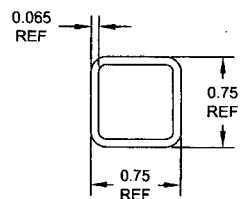
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PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71116

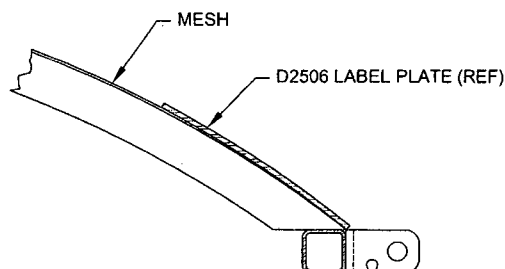


RELEASED
08-06-21/17

E	INCORPORATED D1 & D2 MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

D2512-1/-3/-5/-7 NOTES:

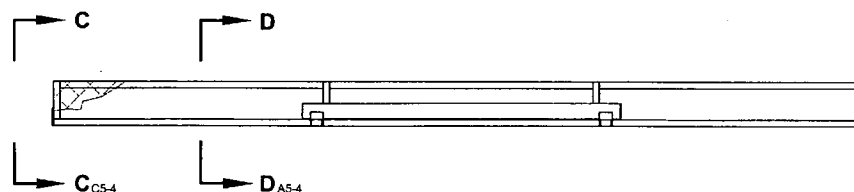
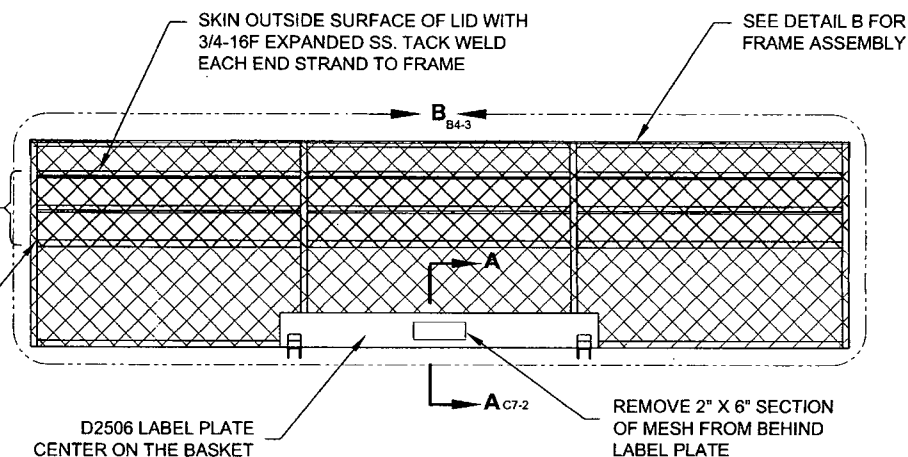
- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST



SECTION A-A_{B3-2}
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED

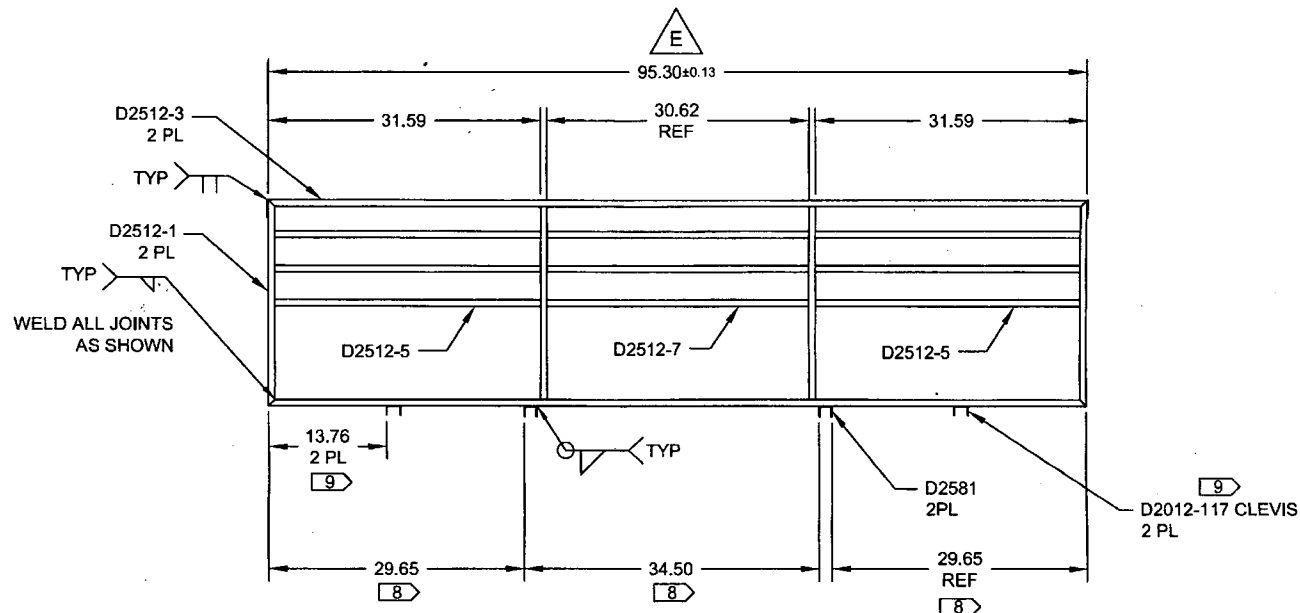


D2512 BASKET LID ASSEMBLY NOTES:

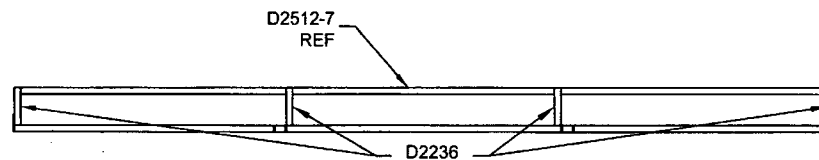
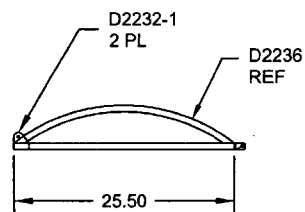
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

RELEASED
08.06.17

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



DETAIL B C3-2
FRAMEWORK ONLY SHOWN FOR CLARITY



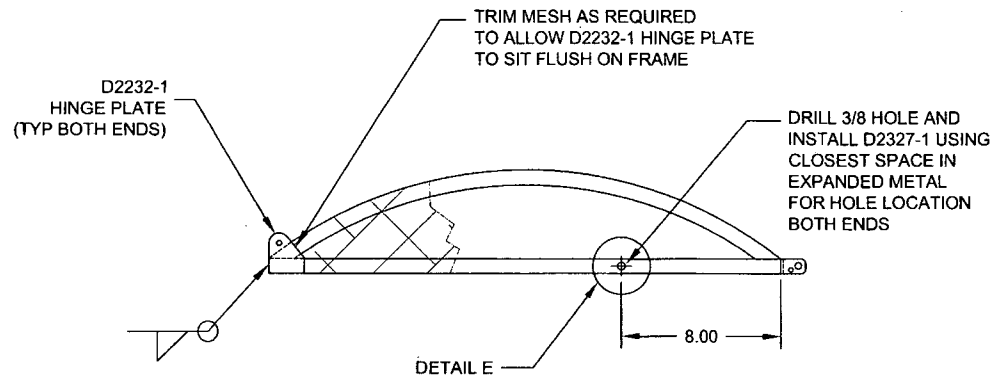
RELEASED
08-06-17

NOTES:

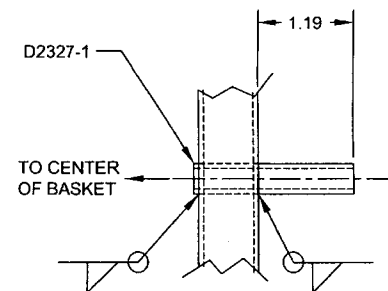
- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
- 9) FOR D130-701-041 ONLY

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	JS	D2512	SHEET 3 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

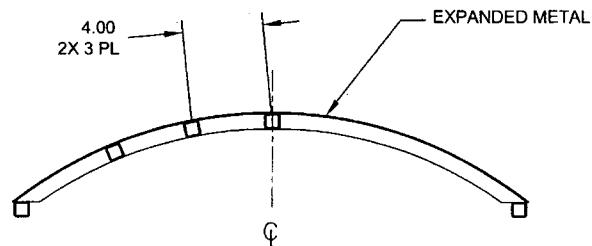
8 7 6 5 4 3 2 1



VIEW C-C SIMILAR BOTH END RIBS A5-2



DETAIL E C6-4



SECTION D-D SAME BOTH CENTER RIBS A4-2

RELEASED
08-06-17

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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8 7 6 5 4 3 2 1